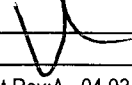
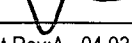


Shg 14/04

Dart Aerospace Ltd.

Date: Wednesday, 11/04/2007 10:30:02 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH
Job Number : 31752	
Estimate Number : 10270	
P.O. Number :	Part Number : D350591311
This Issue : 11/04/2007 S.O. No. :	Drawing Number : D3272 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 31322	Material :
Written By : 	Due Date : 13/04/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A 04.03.22 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

KS 07.04.12 ①

2.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty Part Number	Description	Batch
1 D2622-120	Extrusion	330199

PE 07.04.11 1

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

PE 07.04.11 1
PE 07.04.11 1
PE 07.04.11 1

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PE 07.04.11 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 10:30:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

330143

PE. 07.04.11

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

330468

PE. 07.04.11

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

M100237
M102225

3-Grind End Plate flush

PE. 07.04.11

PE. 07.04.11

PE. 07.04.11

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/11 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/11 ①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R

07/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 10:30:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOI

Job Number: 31752

Part Number: D35

Job Number:



Seq. #:

Machine Or Operation:

Descrip

11.0

QC3

INSPECT POWDER COAT/CHEMIC



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B29978

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B30467

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M102850

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B30143

Rush

*Top Priority
of the
Day
2070411*

SE 07-04-11

SE 07-04-11

SE 07-04-11

SE 07-04-11

SE 07-04-11

SE 07-04-11

Date: Wednesday, 11/04/2007 10:30:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M100237

4-Grind End Plate flush

5-Install last rivet as per Dwg.

Handwritten notes:
P.E. 07-04-11 1
P.E. 07-04-11 1
P.E. 07-04-11 1
P.E. 07-04-11 1
P.E. 07-04-11 1

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: D 07-04-11 ①

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 07-04-11 ②

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

touch up alodine

Handwritten: M.R. 07/04/11 ①

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M.R. 07/04/11 ①

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

Handwritten: m/03707
Fol 07/04/12 ①

Date: Wednesday, 11/04/2007 10:30:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

26.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-3 Mounting Lug B29806 ✓

27.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2618 Bushing B29645 ✓

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2856-400-720 Abrasion Strip B29850 ✓

29.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D3235-1 Mounting Lug B29799 B30850 ✓ 7/4/12 59

Date: Wednesday, 11/04/2007 10:30:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 / Support Assembly B30 563 ✓

1 D3272-041(ref) Step Assembly B31752

31.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M102339 ✓

32.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A Bolt M103363 ✓

33.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt M103481 ✓

34.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M103641 ✓

7/4/12 SQ

Date: Wednesday, 11/04/2007 10:30:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M102929V

36.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M102519V

37.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M102658V

38.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M103919V

39.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M102535V

7/11/12 SA

Date: Wednesday, 11/04/2007 10:30:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 31752

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten: 07/4/12 (1)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location: *PenB*

Handwritten: 07/4/12 (1)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 07/04/12 (1)

Job Completion



Handwritten: 07/04/12



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

w/o 31752

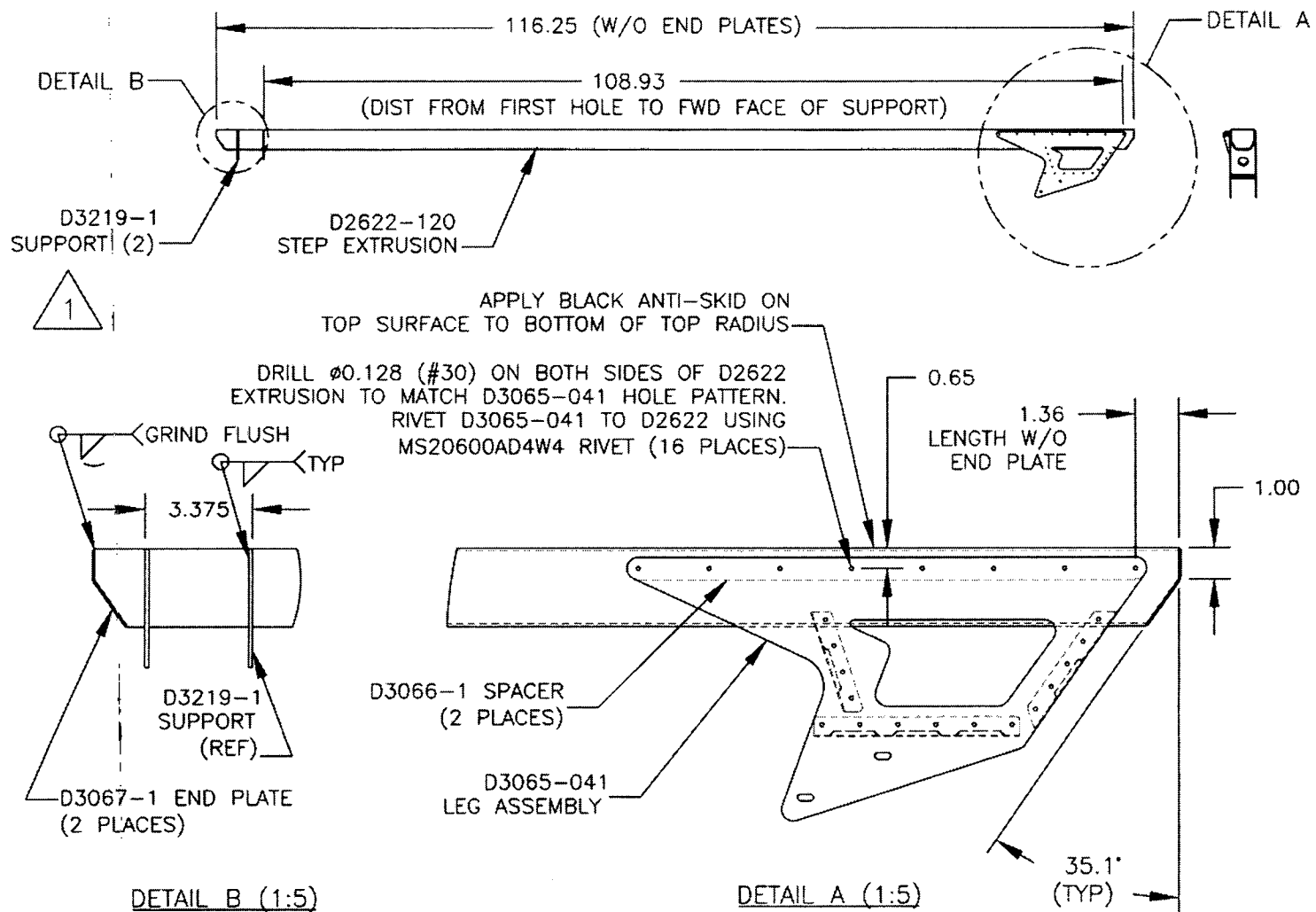
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DART



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP	DRAWING NO.	REV. A
DATE	04.03.01			D3272	SHEET 2 OF 2
				TITLE	SCALE
				STEP ASSEMBLY, HI LONG	1:20



RELEASED
04.04.05